

slip oct 15

Date: Friday, 9/21/2007 1:05:01 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GPS RECEIVER HOUSING
Job Number : 34800
Estimate Number : 12517
P.O. Number : N/A Part Number : D3514047
This Issue : 9/21/2007 S.O. No. : N/A Drawing Number : UNDER REVIEW D3514
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : N/A A 07/09/24
Previous Run : 33292 Material : N/A
Written By : Due Date : 10/12/2007 Qty: 5 Um: Each
Checked & Approved By :
Comment : Est Rev:A New Issue 07-05-28 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D35143 BOX TOP (TOP MOUNTED)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
BOX TOP (BOTTOM MOUNTED)
Batch: B 34821

2.0 D35147 BOX BOTTOM (TOP MOUNTED)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
BOX BOTTOM (BOTTOM MOUNTED)
Batch: B 34822

3.0 D35149 HOOD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
HOOD
Batch: 34823

4.0 D3524041 UPPER AND LOWER PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
UPPER AND LOWER PLATE
Batch: 34824

5.0 MS20426AD3 RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)
RIVET
Batch: M1563

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
27/10/12	9	Split W/O	ES	27/10/12	4			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:05:01 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 34800

Part Number: D3514047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20426AD44

Rivet



Comment: Qty.: 11.0000 Each(s)/Unit Total : 55.0000 Each(s)

Rivet

Batch: M1021

PO

7.0

MS20426AD49

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

RIVET

Batch: M18136

PO

8.0

MS21072L06

ANCHOR NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

ANCHOR NUT

Batch: M101760

PO 7/9/11

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3514

mf 07-10-12 (4)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1 SB 07/10/12

11.0

POWDER COATING

POWDER COATING



M102316



(4x)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m-l 07/10/12

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 07-10-13 (4)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble trim as per dwg D3514

mf 07-10-15 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: DD Date: 07/10/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:05:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 34800

Part Number: D3514047

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D35261

RUBBER SEAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
RUBBER SEAL

B 34825 MF 07-10-15

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/15

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA

SB 07/10/15

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/10/15

Job Completion



U 07-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

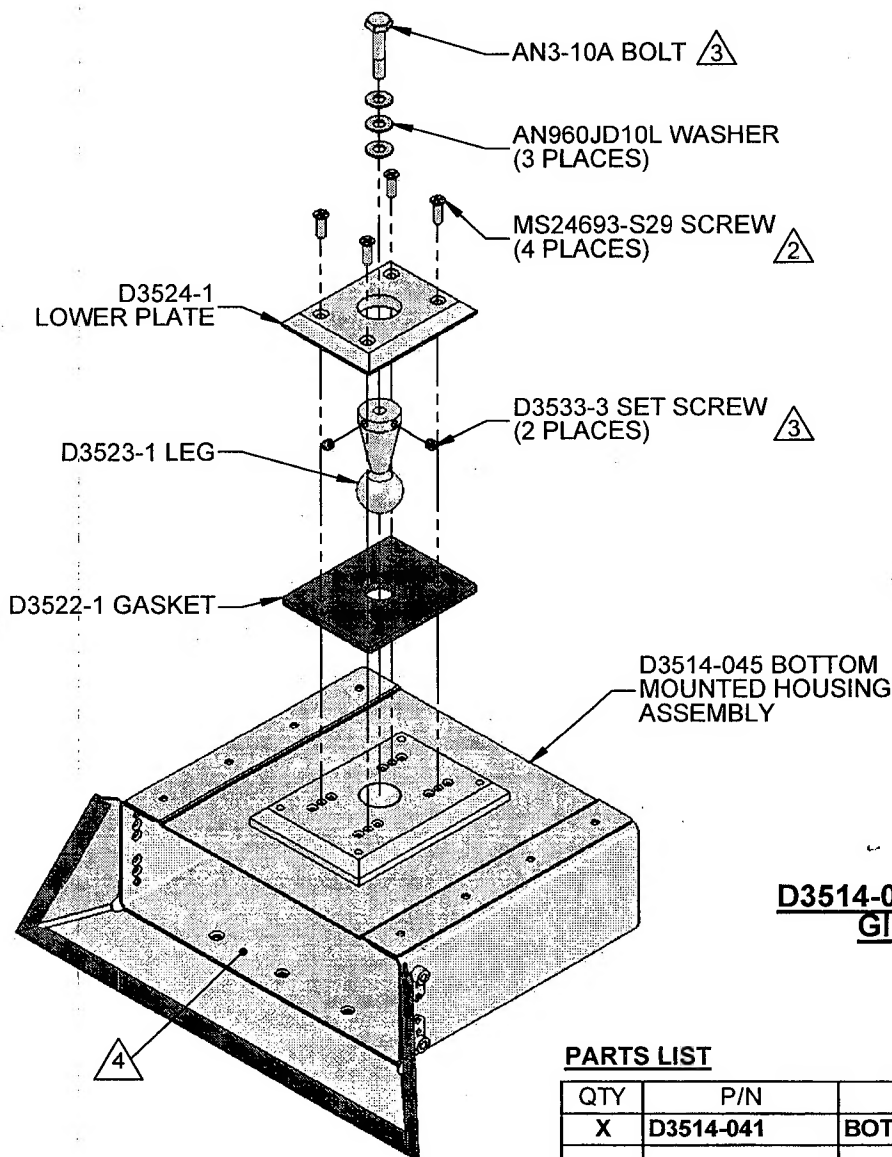
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3
REV A	DATE 07.06.18	DESCRIPTION NEW ISSUE	



RELEASED
07.08.03

**D3514-041 BOTTOM MOUNTED
GIMBAL ASSEMBLY**

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-041	BOTTOM MOUNTED GIMBAL ASSEMBLY
1	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-1	LEG
1	D3524-1	LOWER PLATE
2	D3533-3	SET SCREW
1	AN3-10A	BOLT
3	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TIGHTEN TO SNUG FIT ONLY
- 4) IDENTIFY WITH DART P/N "D3514-041" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

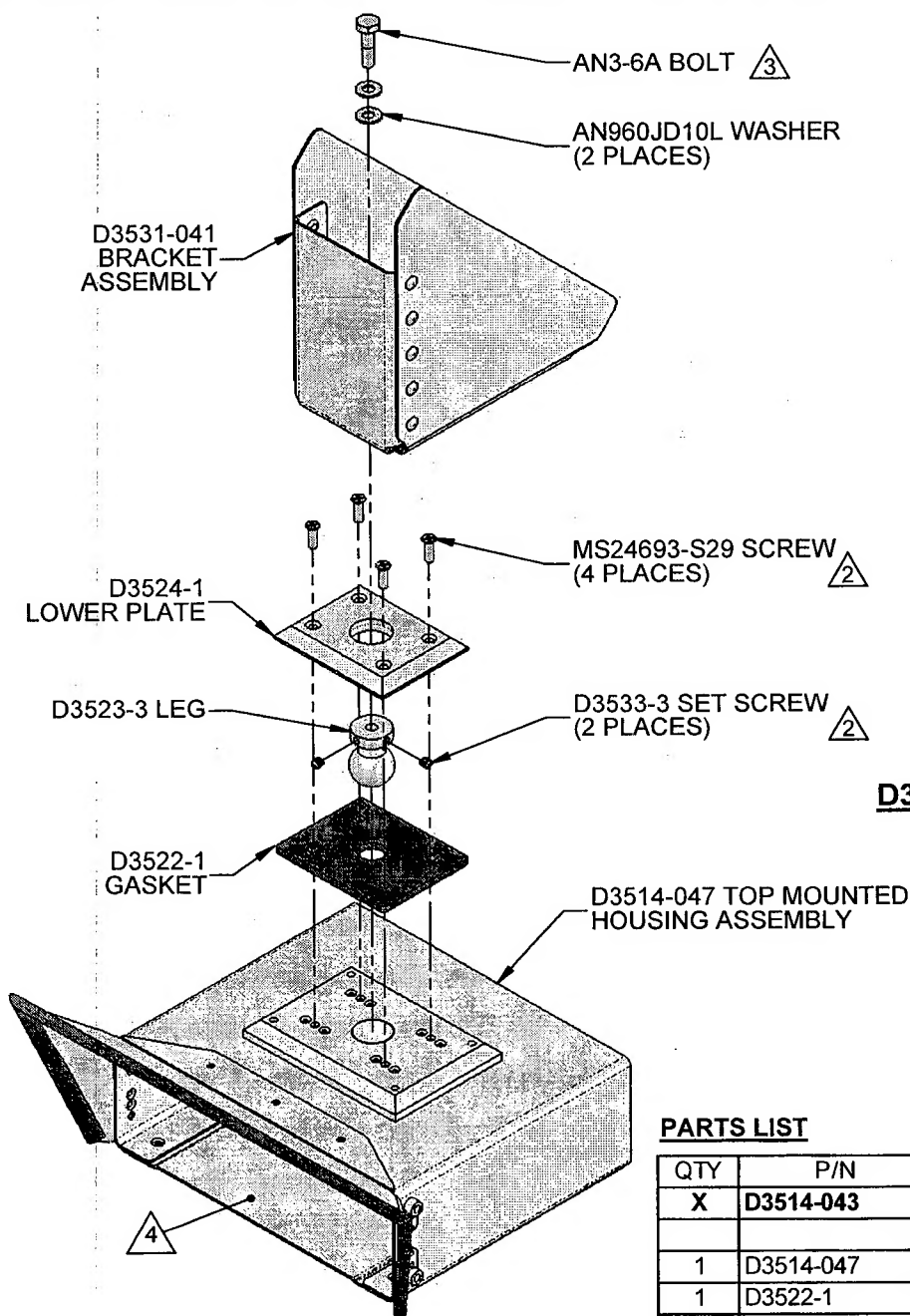
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DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 2 OF 9 SCALE 1:3

RELEASED
07.08.03



D3514-043 TOP MOUNTED GIMBAL ASSEMBLY

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-043	TOP MOUNTED GIMBAL ASSEMBLY
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-3	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
2	D3533-3	SET SCREW
1	AN3-6A	BOLT
2	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

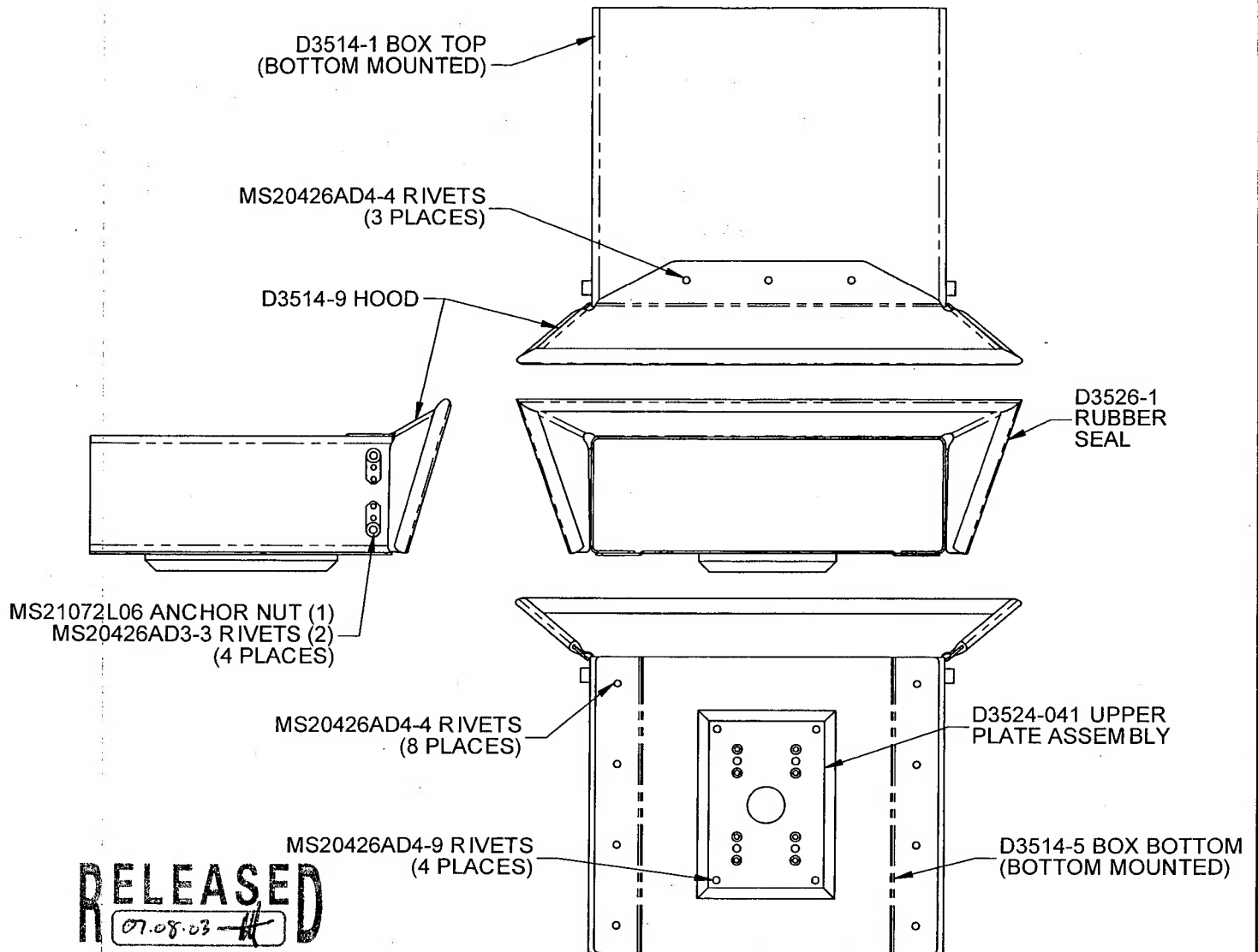
- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3



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07.08.03 **#**

D3514-045 BOTTOM MOUNTED HOUSING ASSEMBLY

NOTES:

- 1) POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

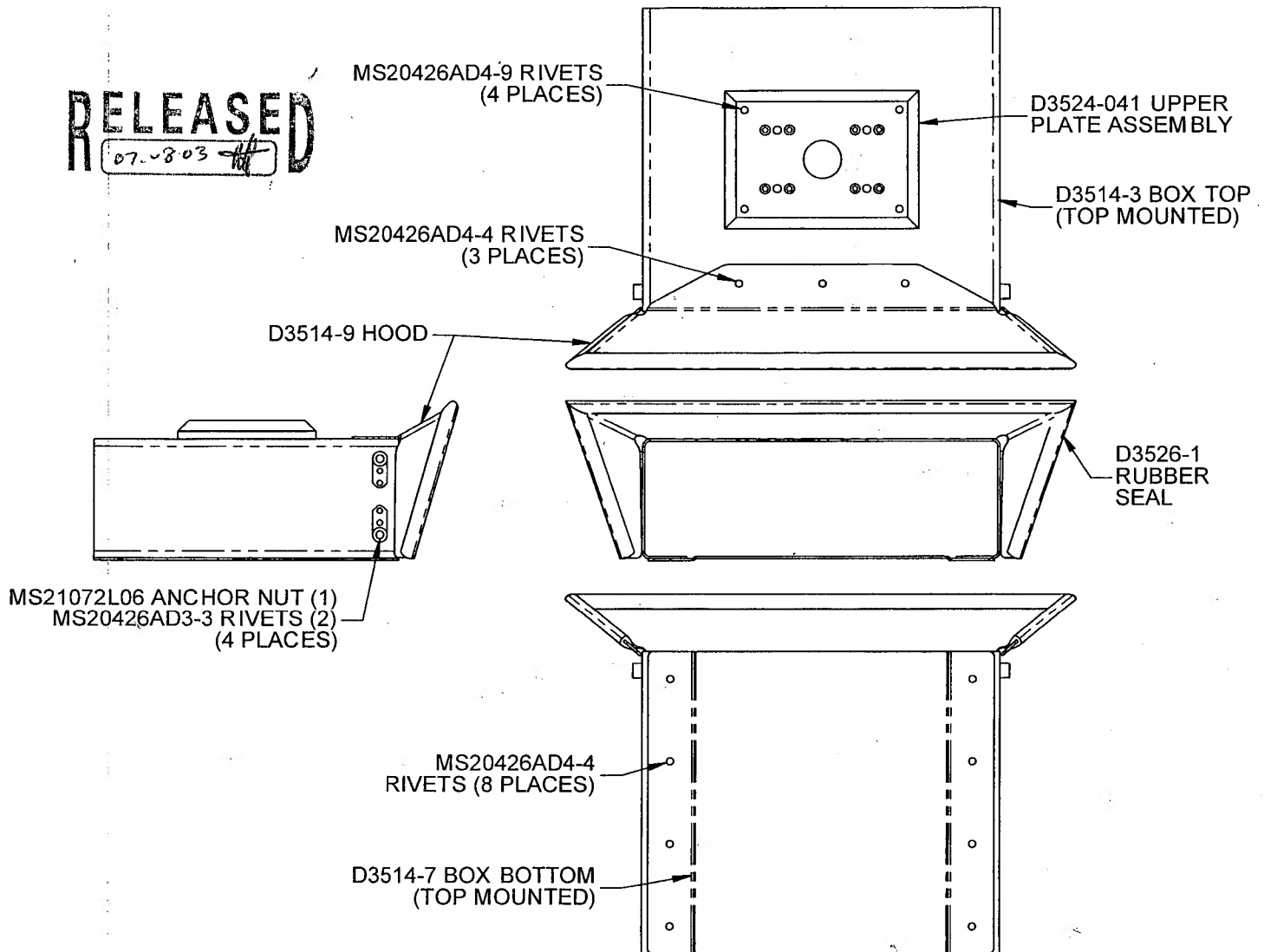
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DATE 07.06.18	TITLE GPS RECEIVER HOUSING		SCALE 1:3

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07-08-03



**D3514-047 TOP MOUNTED
HOUSING ASSEMBLY**

NOTES:

- 1) POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003


PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3514-3	BOX TOP (TOP MOUNTED)
1	D3514-7	BOX BOTTOM (TOP MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

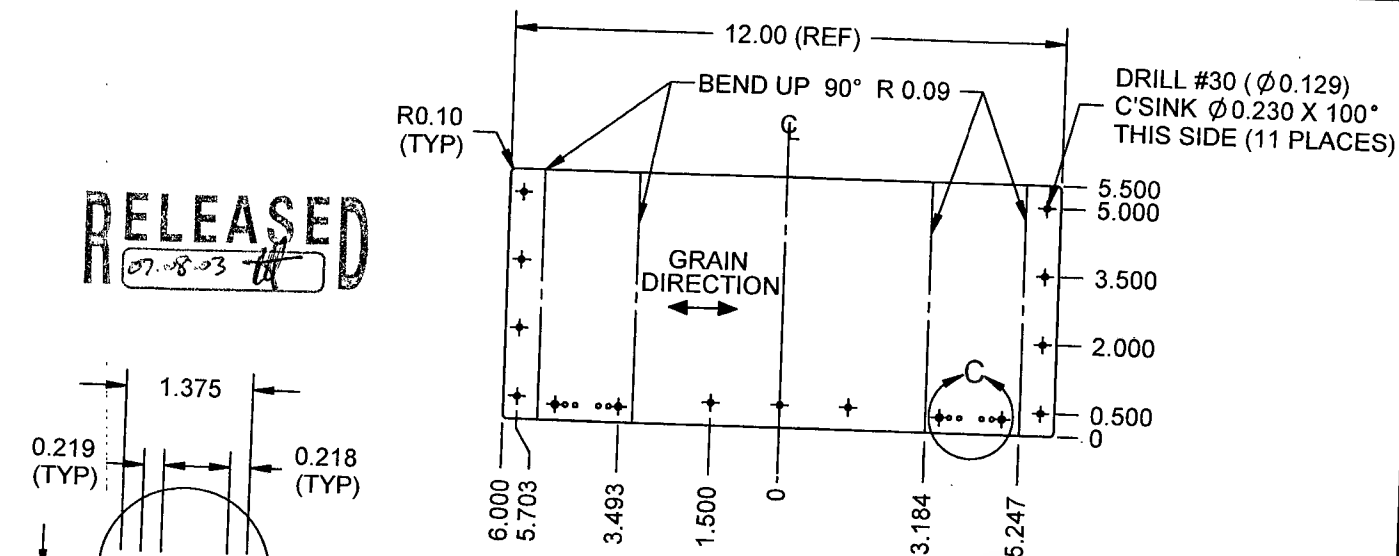
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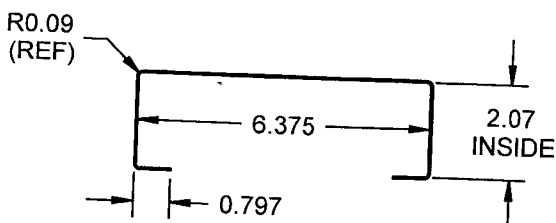
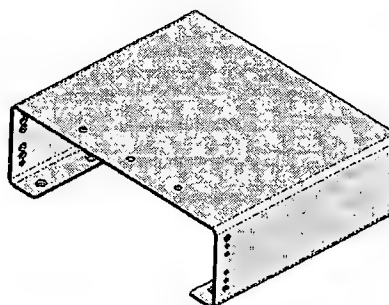


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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SHEET 5 OF 9
			SCALE 1:4

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07.08.03



**D3514-1F
FLAT PATTERN**



D3514-1 BOX TOP (BOTTOM MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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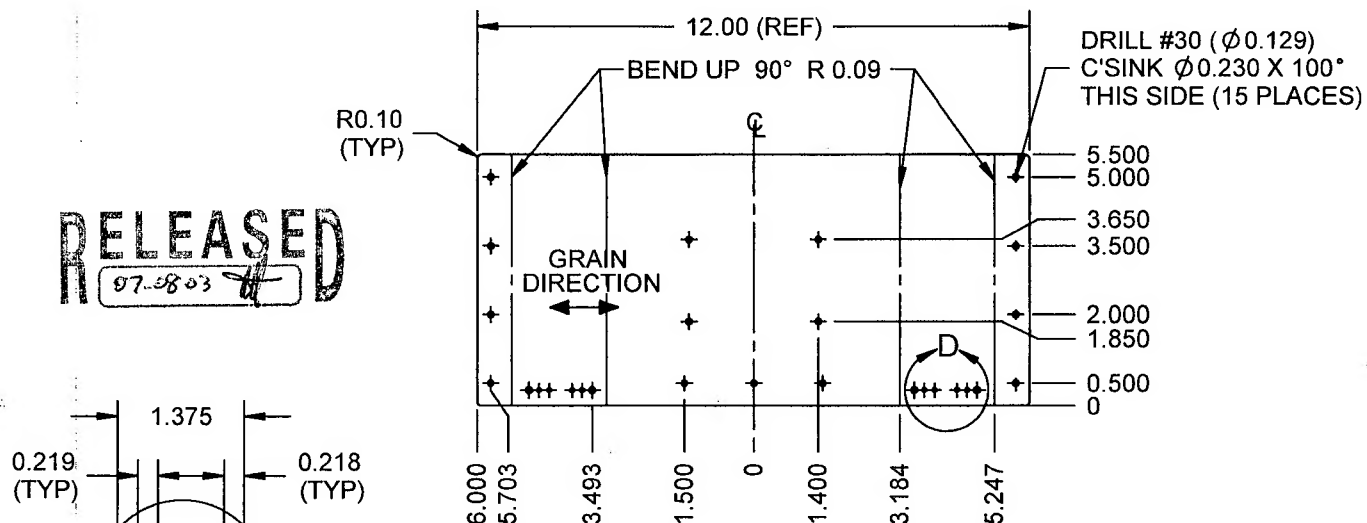
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:4

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97-5803

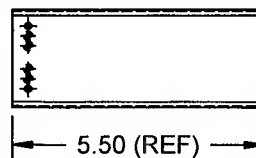
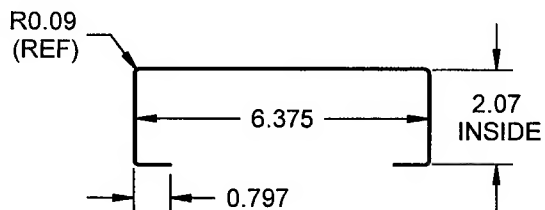
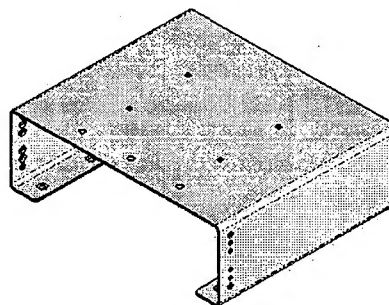


**D3514-3F
FLAT PATTERN**

**DETAIL D
SCALE 1:2**

DRILL #27 (Ø0.144)
(4 PLACES)

DRILL #40 (Ø0.098)
C'SINK Ø0.182 X 100° THIS SIDE
(8 PLACES) FOR RIVETS



D3514-3 BOX TOP (TOP MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

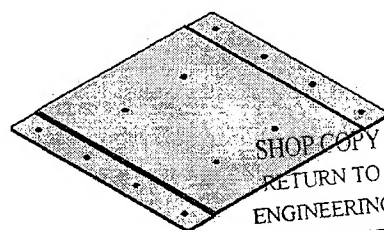
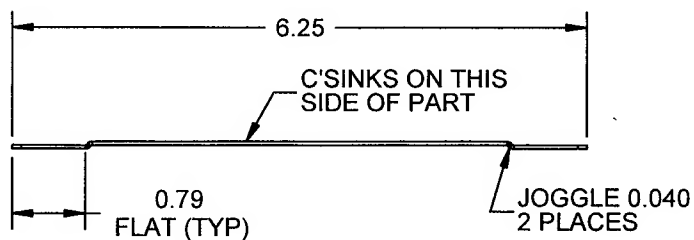
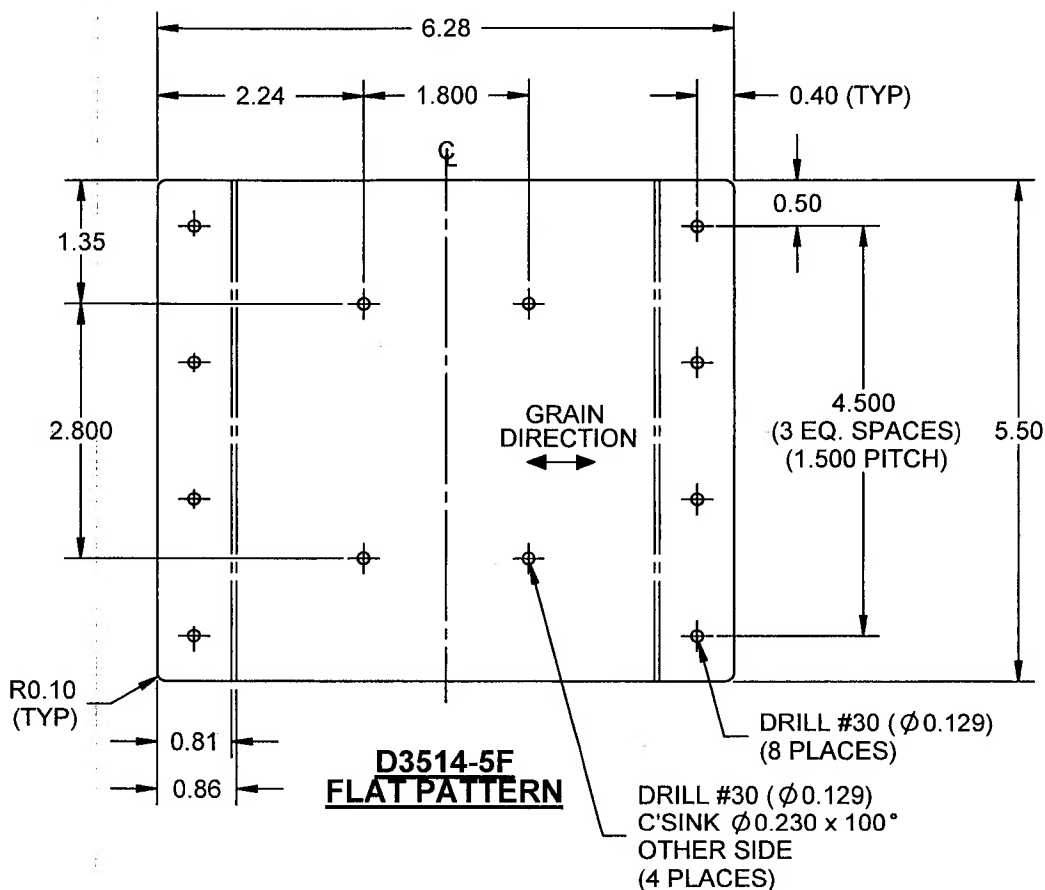
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2



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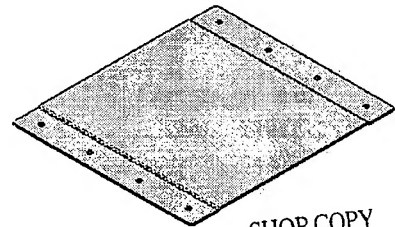
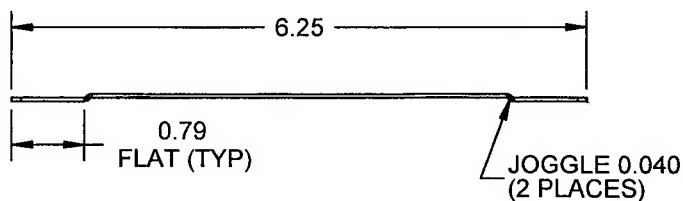
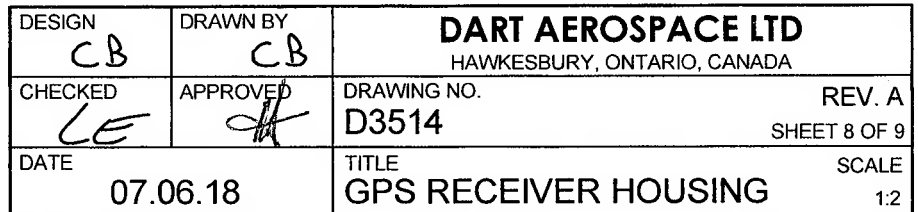
NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT \bar{C}
- 7) C'SINK ABOVE JOGGLE

RELEASED
07.08.03 [Signature]

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2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP CORNERS TO 0.010 MAX

6) PART IS SYMMETRIC ABOUT C

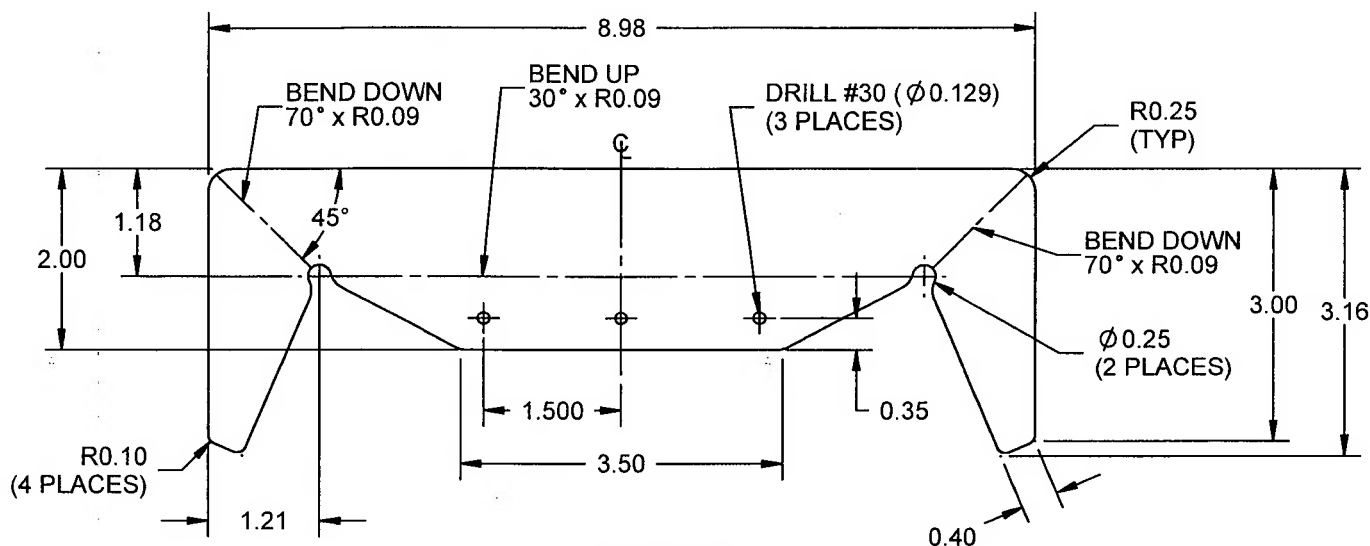
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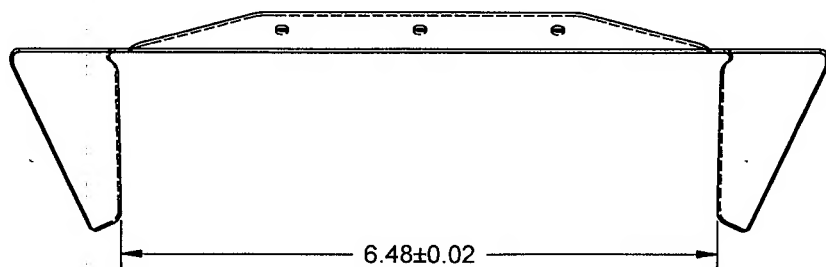
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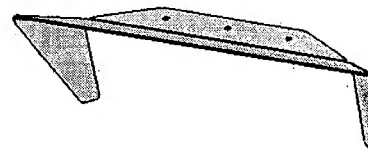
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2



**D3514-9F
FLAT PATTERN**



FRONT VIEW



D3514-9 HOOD

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

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